

DESLEN™ DSC511FM4

Polypropylene

DESCO Co., Ltd.

Message:

Descriptions: DESLEN™ DSC511FM4 is Polypropylene Mineral Filler 20% reinforced resin. It has Flame retardant grade which has UL V-2 grade.

Applications: DESLEN™ DSC511FM4 is applied to Electronic Parts, Back Cover and Bobbin which request non flammability and good mechanical property.

General Information			
Filler / Reinforcement	Mineral filler, 20% filler by weight		
Features	Rigidity, high		
	Thermal stability, good		
	Flame retardancy		
Uses	Protective cover		
	Electrical/Electronic Applications		
	spool		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.2 - 1.3	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	95		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	29.4	MPa	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
Flexural Modulus	2260	MPa	ASTM D790
Flexural Strength	53.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	39	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	143	°C	ASTM D648
1.8 MPa, not annealed	90.0	°C	ASTM D648
Melting Temperature	163	°C	DSC
Flammability	Nominal Value	Test Method	
Flame Rating	V-2	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	

Suggested Max Moisture	< 0.20	%
Rear Temperature	190 - 200	°C
Middle Temperature	200 - 210	°C
Front Temperature	200 - 220	°C
Nozzle Temperature	200 - 220	°C
Processing (Melt) Temp	200 - 220	°C
Mold Temperature	40.0 - 60.0	°C

Injection instructions

Speed: 40 to 70%Pressure 1st: 30 to 60%Pressure 2nd: 30 to 60Holding Pressure: 10 to 20%

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